

Date: Wednesday, 5/16/2007 1:42:41 PM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	GASKET		
Job Number	32414				
Estimate Number	12714				
P.O. Number	N/A	Part Number	D353639		
This Issue	5/16/2007	S.O. No.	N/A		
Prsht Rev.	NC	Drawing Number	D3536 REV A		
First Issue	N/A	Project Number	N/A		
Previous Run	30756	Type	SMALL /MED FAB		
Written By		Material	N/A		
Checked & Approved By	5/16/07	Due Date	5/31/2007		
Comment	Qty: 12 Um: Each Est Rev:A New Issue 07-02-14 JLM				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	MNEO60S063	NEOPRENE SHEET 0.063		
Comment: Qty.: 0.7911 sf(s)/Unit Total : 9.4928 sf(s) NEOPRENE SHEET 0.063 Batch: BH M103104 <span style="float: right;">SAD 07/05/28</span>				
2.0	WATER JET	FLOW WATER JET		
Comment: FLOW WATER JET 1-Cut as per Dwg D3536 Dwg Rev: A Prog Rev: A  2-Deburr if necessary <span style="float: right;">SAD 07/05/28</span>				
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <span style="float: right;">SAD 07/05/28</span>				
4.0	QC8	SECOND CHECK		
Comment: SECOND CHECK <span style="float: right;">14</span>				
5.0	PACKAGING 1	PACKAGING RESOURCE #1		
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <span style="float: right;">E/S 07/05/29 14</span>				

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/05/29  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Wednesday, 5/16/2007 1:42:41 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 32414

Part Number: D353639

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



(14)

Comment: FINAL INSPECTION/W/O RELEASE

5/16/07

Job Completion



U 5/05/29

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	32414
Description: Gasket		Part Number:	D3536-39
Inspection Dwg: D3536	Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

First Article  Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
35.71	+/-0.030	35.710	/		M-T	
32.78	+/-0.030	32.78	/		M-T	
29.28	+/-0.030	29.27	/		M-T	
25.78	+/-0.030	25.78	/		M-T	
23.25	+/-0.030	23.25	/		M-T	
19.75	+/-0.030	19.75	/		M-T	
17.75	+/-0.030	17.75	/		M-T	
14.25	+/-0.030	14.25	/		M-T	
9.50	+/-0.030	9.50	/		Vern	
4.75	+/-0.030	4.751	/		Vern	
5.00	+/-0.030	5.00	/		Vern	
9.00	+/-0.030	9.00	/		Vern	
0.30	+/-0.030	0.31	/		Vern	
0.30	+/-0.030	0.31	/		Vern	
1.88	+/-0.030	1.900	/		Vern	
Ø0.19	+0.005/-0.001	Ø0.200	/		Vern	
0.063	+/-0.010	0.061	/		Vern	

Measured by:	SAD
Date:	07/05/28

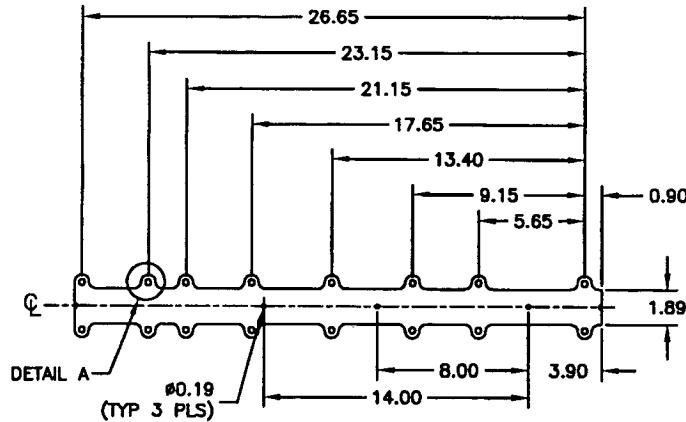
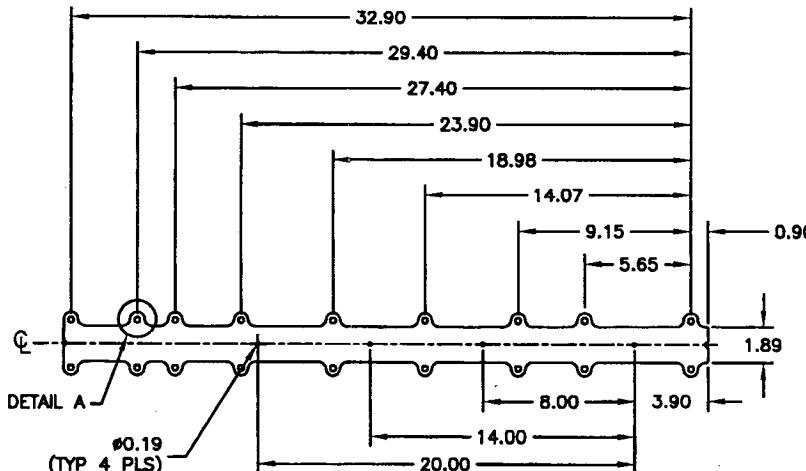
Audited by:	/
Date:	0705-29

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM	SAD

**DART**

89-02-12-6

**D3536-11 GASKET****D3536-13 GASKET**

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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 32414

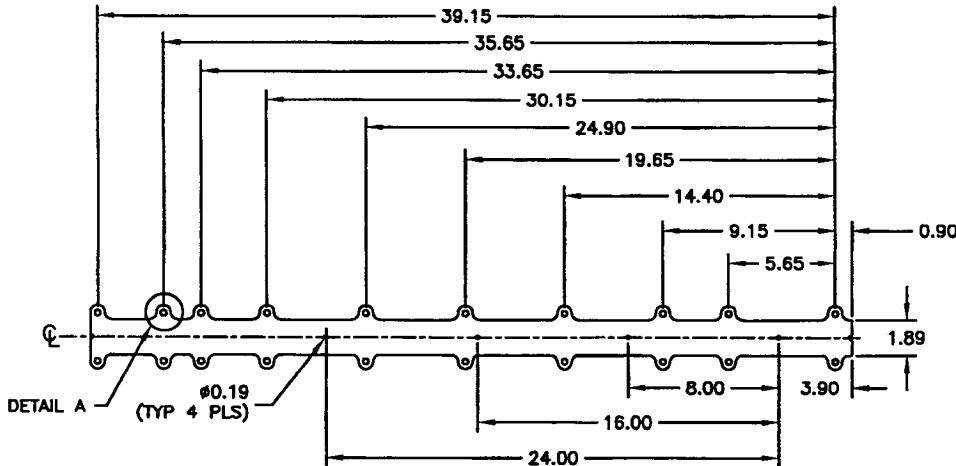
**NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT  $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

DESIGN <b>CB</b>	DRAWN BY <b>CB</b>	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <b>PH</b>	APPROVED <b>PH</b>	DRAWING NO. D3536
DATE 06.10.25	DATE 06.10.25	TITLE GASKET
A	06.10.25	NEW ISSUE

**DART**

RELEASED  
07.02.12

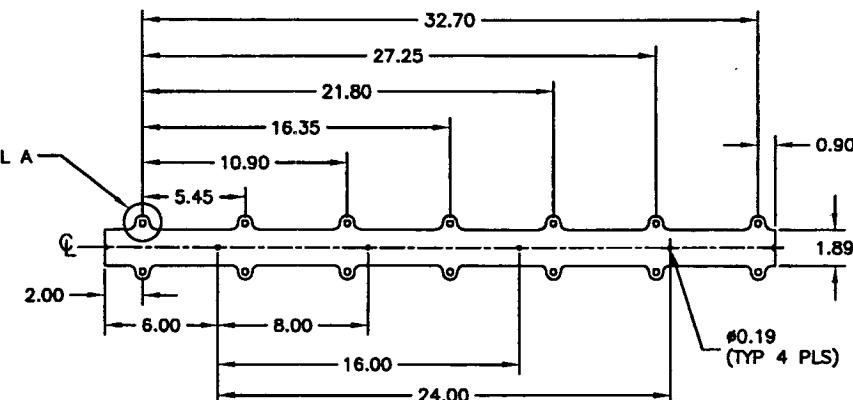


**D3536-15 GASKET**

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NO. 32414

**NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT  $\frac{1}{4}$
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- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



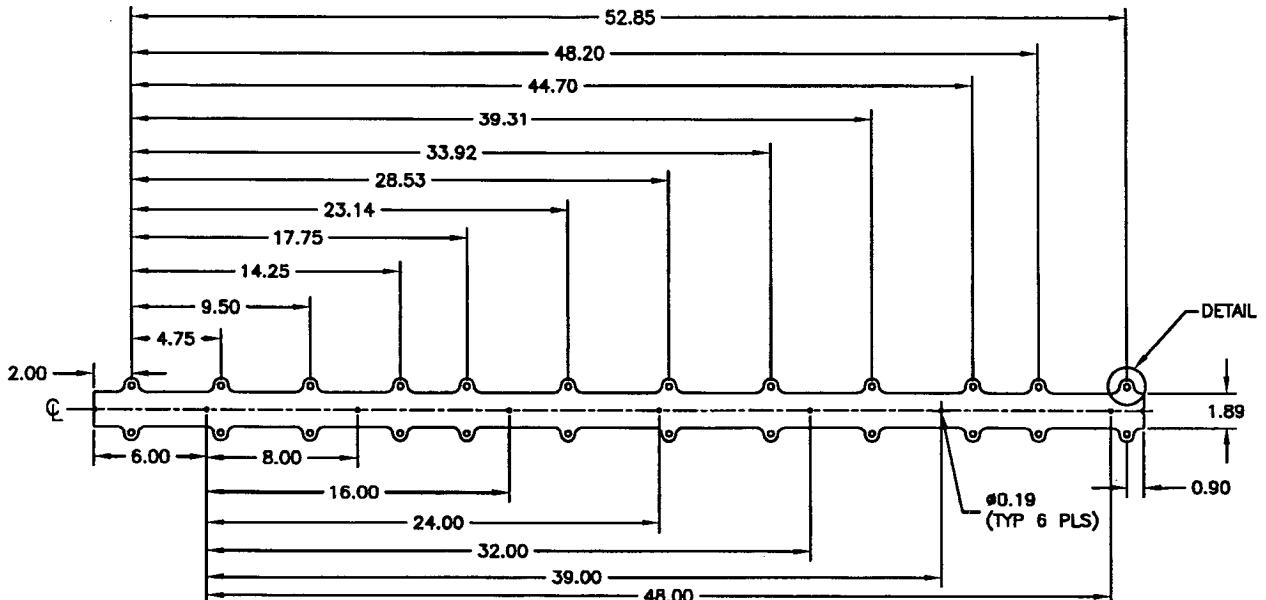
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CHECKED	APPROVED	DRAWING NO.
<b>PH</b>	<b>TH</b>	D3536
DATE	TITLE	REV. A
06.10.25	GASKET	SHEET 2 OF 6
		SCALE
		1:10

**DART**

07-02-12  
07-02-12  
07-02-12

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
C.B	C.B	PORT HADLOCK, WA
DATE	APPROVED	DRAWING NO. D3536
06.10.25	MM	TITLE GASKET

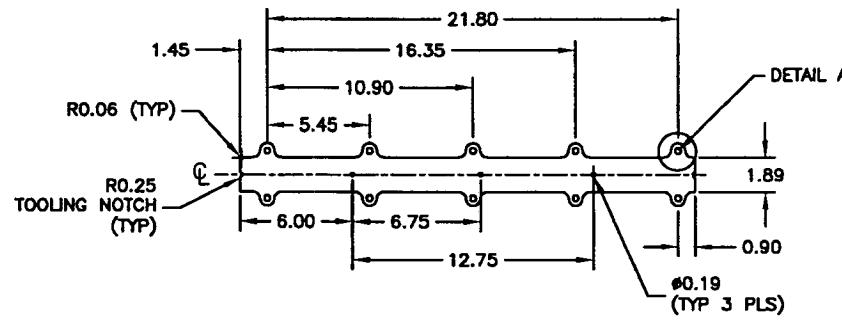


**D3536-23 GASKET**

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NO. 32414

**NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
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- 7) SEE PAGE 6 FOR DETAILS AND SECTION

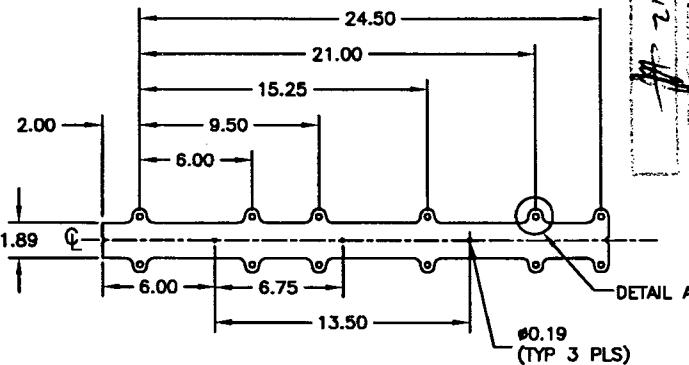


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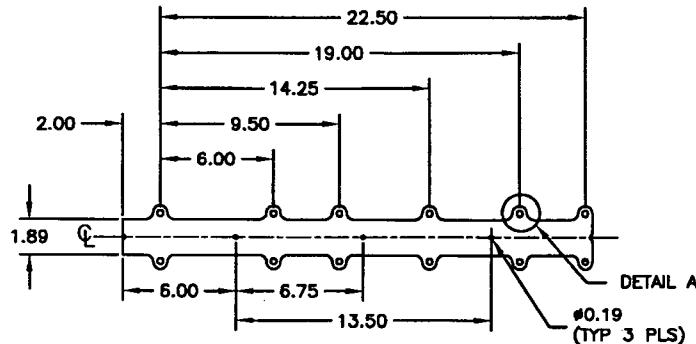
**DART**

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DATE <b>06.10.25</b>		SCALE 1:10

07.02.12 *[Signature]*



**D3536-33 GASKET**

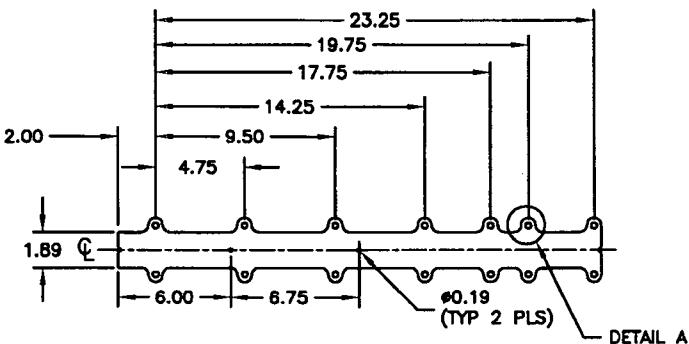


**D3536-31 GASKET**

**NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
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- SEE PAGE 6 FOR DETAILS AND SECTION

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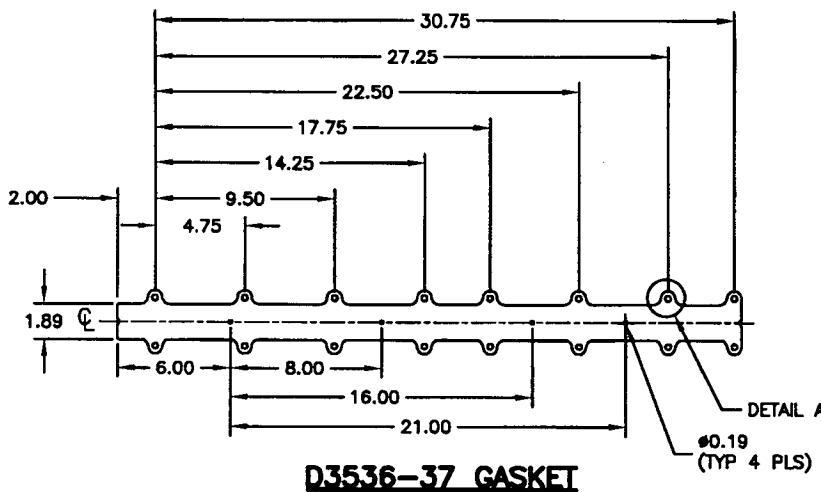


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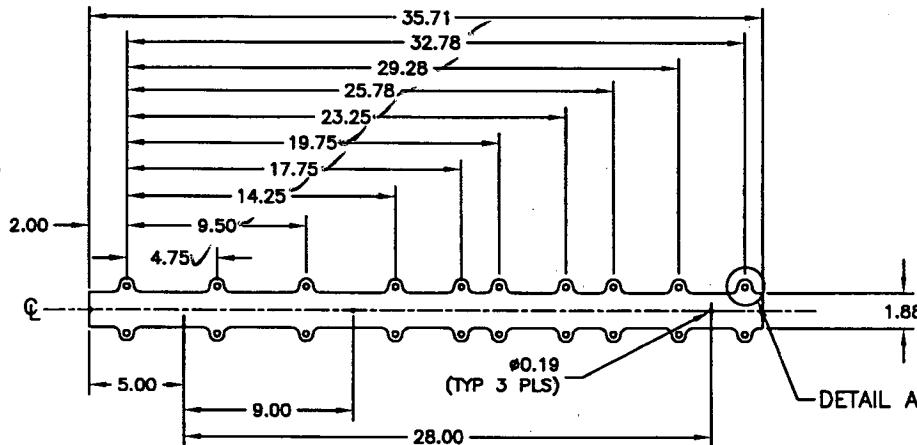
**DART**

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DATE 06.10.25	TIME	SCALE 1:10

07.02.02  
PH

**D3536-37 GASKET****NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
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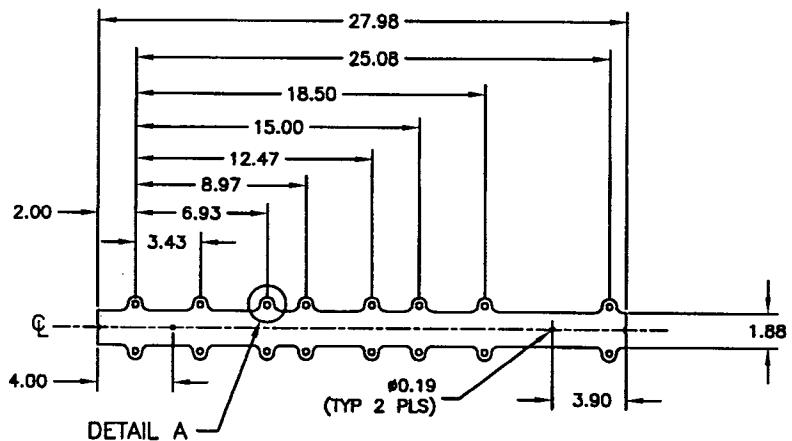
**D3536-39 GASKET**

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<i>PH</i>	<i>PH</i>	D3536
DATE	TITLE	REV. A
06.10.25	GASKET	SHEET 6 OF 6
		SCALE
		1:10

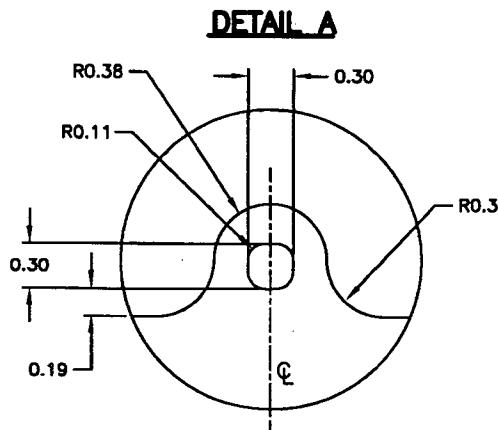
07.02.12 *PH*



**D3536-41 GASKET**

**NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
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- 3) PART IS SYMMETRICAL ABOUT  $\frac{C}{4}$
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